

7 Dec

Work Order ID 92678

92678

Page 1

November-07-12 1:52:34 PM

Item ID: D350-567-141

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Window Closeout Installation

Start Date: 11/06/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MJS Date: 12-11-08 Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9590	C
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SP

0.00

DA
15
2-83

100

100

DOCUMENT CONTROL

0.00

12 12 06

DC

Memo

Document Control

Photocopy bluefile & type labels per PPP D350-567-141 CHG002

4

MJS

12-11-24

SP

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

4x

SP

12-11-27

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DA
15
2-83

12 12 06

4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ _____
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Work Order ID 92678

92678

Page 2

November-07-12 1:52:34 PM

Item ID: D350-567-141

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Window Closeout Installation

Start Date: 11/06/12 Start Qty: 4.00

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Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					(40)		12/12/12	20
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-141 Location: <u>SHIP</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 12-12-06

ML5 12-12-06

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

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Page 1

Work Order ID: 92678

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/06/12

Required Date: 11/30/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER
ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3802-1 Window Seal		Manufactured	No			110	f	431.5500	2	8			
------------------------	--	--------------	----	--	--	-----	---	----------	---	---	--	--	--

4x 24" SMD 4X

Location	Loc Qty	Loc Code
ST408	431.55	
56881	0.75	
81021	2	
81868	428.8	

D4434-041 Fwd Bracket Assembly		Manufactured	No			110	Each	7.0000	1	4			
-----------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

SMD 4X

Location	Loc Qty	Loc Code
ST272	6	
85859	6	
ST274	1	
83538	1	

D4434-047 Cover Assembly		Manufactured	No			110	Each	4.0000	1				
-----------------------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

SMD 4X

Location	Loc Qty	Loc Code
ST273	4	
85839	4	

D4435-045 T/R Bellcrank Cover Assembly		Manufactured	No			110	Each	3.0000	1				
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

SMD 4X

Location	Loc Qty	Loc Code
ST273	3	
83535	3	

D4435-9 Bracket		Manufactured	No			110	Each	4.0000	2				
--------------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

SMD 4X

Location	Loc Qty	Loc Code
ST441	4	
87534	4	

6x B 93510
SP 12-11-27
2x B93342

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

#	Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
	Doc/Data									
	Equip/Tooling									
	Operator									
	Material									
	Setup									
	Other									
	Process									
	Supplier									
	Training									
	Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

November-07-12 1:52:33 PM

Work Order ID: 92678

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/06/12

Required Date: 11/30/12

Start Qty: 4.00

Required Qty: 4.00

D4436-041
Aft Bracket Assembly

Manufactured No

110 Each 2.0000

1 4 939/3 ESD

SMD

Location Loc Qty Loc Code

ST273 2
85861 2

D4441-1
Rubber Seal

Manufactured No

110 f 655.1146

2 8 SP.

4X 24"
SMD 4X

Location Loc Qty Loc Code

ST412 655.1146
74760 6.119
79385 0.0476
80763 163.54
86185 485.408

AN3-3A
Bolt

Purchased No

110 Each 300.0000

7 28 SP

SMD 4X

Location Loc Qty Loc Code

ST350 300
122800 200
123352 100

AN525-832R7
Screw

Purchased No

110 Each 438.0000

2 8 SP

SMD 4X

Location Loc Qty Loc Code

ST345 438
120519 34
120560 404

MS21042L06
Nut

Purchased No

110 Each 366.0000

7 28 SP 12-11-27

SMD 4X

Location Loc Qty Loc Code

315 272
122441 272
ST317 94
122151 94

28x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

November-07-12 1:52:33 PM

Work Order ID: 92678

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/06/12

Required Date: 11/30/12

Start Qty: 4.00

Required Qty: 4.00

MS21042L08

Purchased

No

110

Each

986.0000

2

8

Nut

Sm 4X

Location

Loc Qty

Loc Code

315

9

122452

9

ST315

500

122814

500

ST317

477

122141

477

MS21042L3

Purchased

No

110

Each

2,608.0000

5

20

Nut

Sm 4X

Location

Loc Qty

Loc Code

316

619

122452

619

ST300

225

117885

32

119017

55

119075

138

ST314

1394

123265

1394

ST317

370

122141

370

Sk

SP 12-11-27

20x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

November-07-12 1:52:33 PM

Work Order ID: 92678
 Parent Item: D350-567-141
 Parent Item Name: Floor Window Closeout Installation

Start Date: 11/06/12

Required Date: 11/30/12

Start Qty: 4.00

Required Qty: 4.00

MS21059L3 Purchased No

110 Each 227.0000 2 8

Nut Plate

SMS 4X

Location	Loc Qty	Loc Code
302	10	
121185	10	
314	3	
122452	3	
ST301	28	
118614	8	
119546	20	
ST302	124	
120308	13	
120833	1	
121444	100	
121524	10	
ST316	62	
122814	62	

8x

MS35206-229
 Screw

Purchased No

110 Each 79.0000 7 28

SMS 4X

Location	Loc Qty	Loc Code
ST293	79	
121039	79	

23x

SP

SP 12-11-27.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

November-07-12 1:52:33 PM

Work Order ID: 92678
 Parent Item: D350-567-141
 Parent Item Name: Floor Window Closeout Installation

Start Date: 11/06/12

Required Date: 11/30/12

Start Qty: 4.00

Required Qty: 4.00

NAS1149F0332P Purchased No

110 Each 1,222.0000 12 48

WASHER

Location Loc Qty Loc Code

275 246
 122441 246
 ST275 776
 117735 13
 119225 8
 121259 138
 121825 14
 122063 600
 17317 3
 ST295 200
 123352 200

SMA 4X

~~48~~ 43x

5x

NAS1149FN616P Purchased No

110 Each 669.0000 14 56

WASHER

Location Loc Qty Loc Code

ST275 669
 117317 15
 120560 654

SMA 4X

56x

NAS1149FN816P Purchased No

Each 729.0000

WASHER

Location Loc Qty Loc Code

ST275 729
 117316 215
 121039 514

SMA 4X

2⁸ SP12-1127

8x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data	<input type="checkbox"/>											
Equip/Tooling	<input type="checkbox"/>											
Operator	<input type="checkbox"/>											
Material	<input type="checkbox"/>											
Setup	<input type="checkbox"/>											
Other	<input type="checkbox"/>											
Process	<input type="checkbox"/>											
Supplier	<input type="checkbox"/>											
Training	<input type="checkbox"/>											
Unapproved	<input type="checkbox"/>											
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.

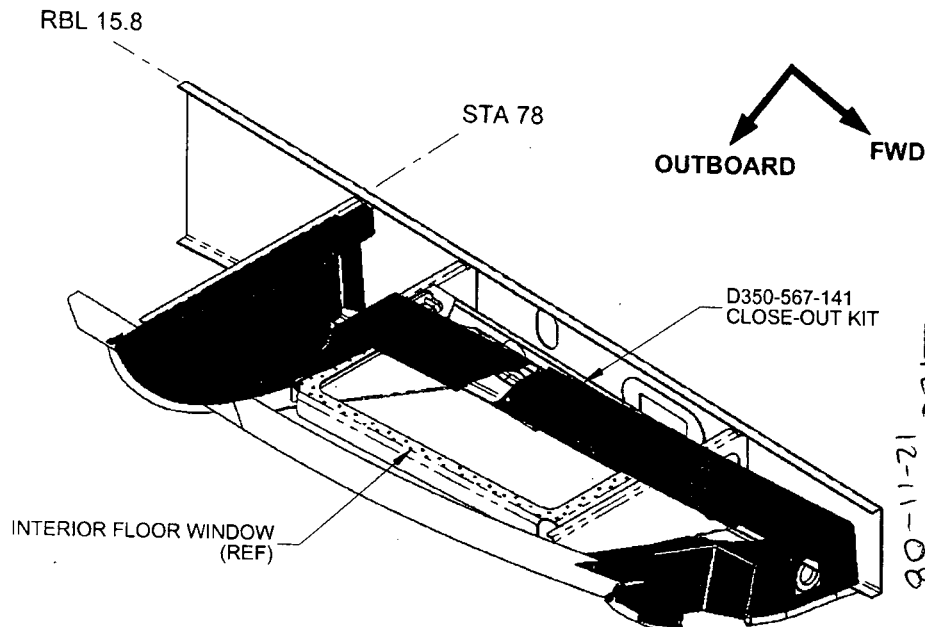


Figure 1. Floor Window Close-out Kit Installation

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.03.13
CERT. NO.: SH92-18
ISSUE NO.: 6

C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
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2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

C

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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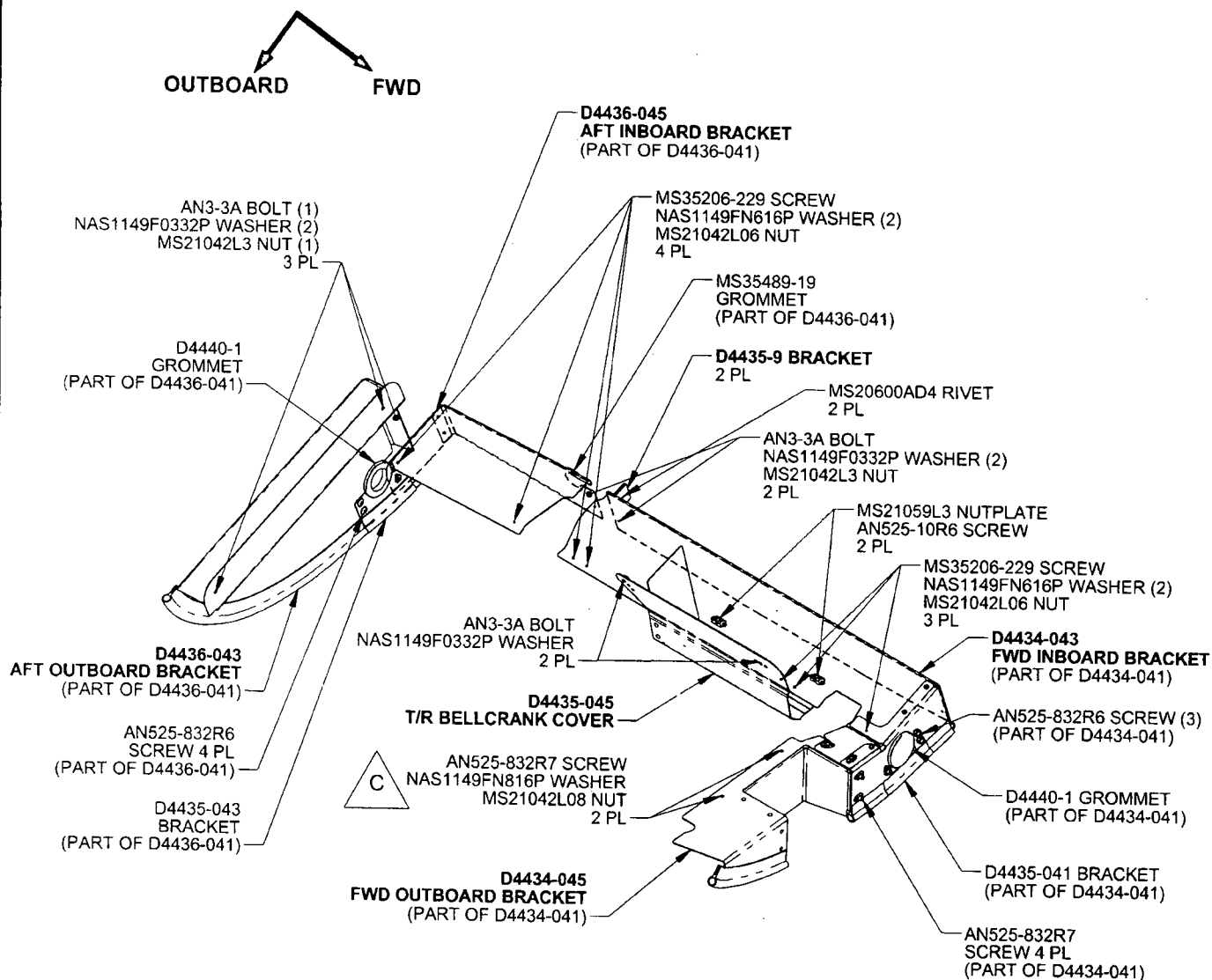


Figure 2. Floor Window Close-out Kit Installation

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- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
- Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill $2 \times \varnothing 0.144$ holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill $2 \times \varnothing 0.144$ holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill $2 \times \varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill $2 \times \varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill $2 \times \varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill $2 \times \varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.



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BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

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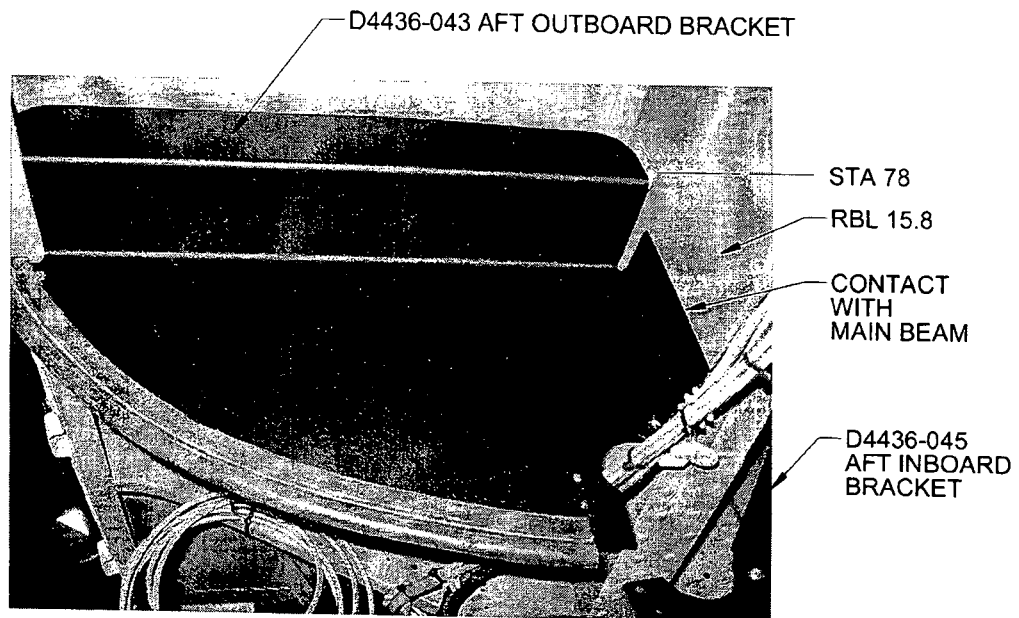


Figure 3. D4436-043 Aft Outboard Bracket Installation

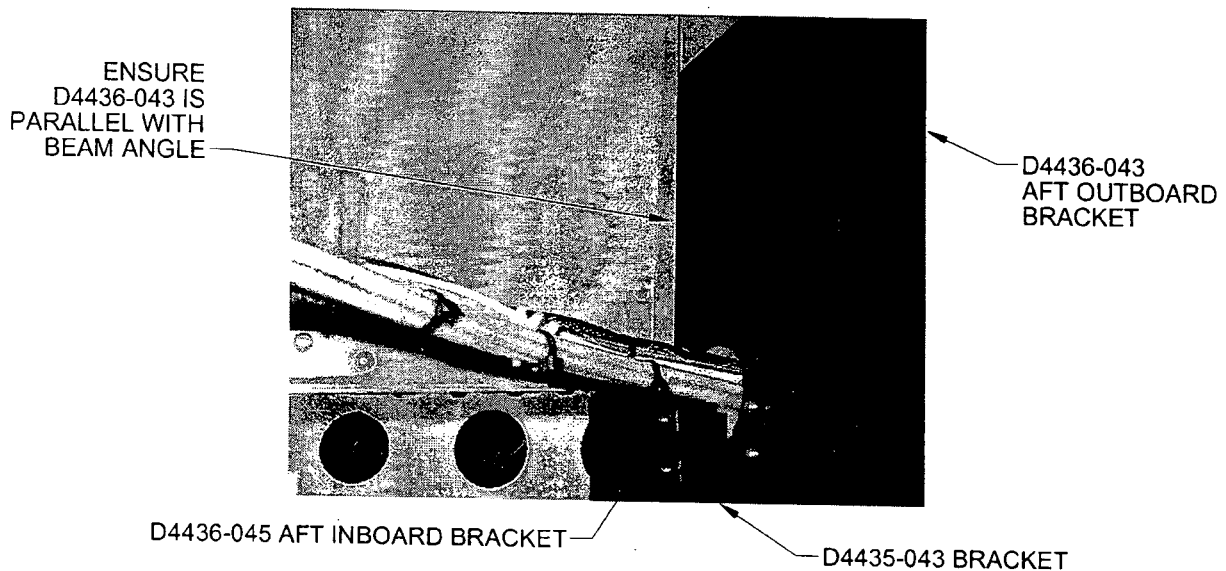


Figure 4. D4436-043 & D4435-043 Brackets Installation

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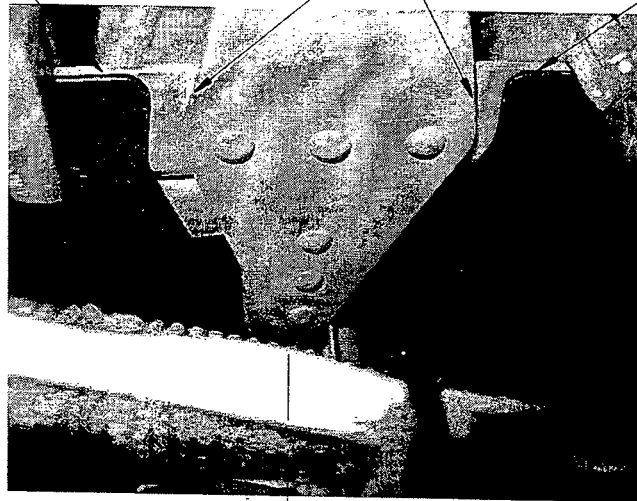
82926

D4436-045 AFT INBOARD
BRACKET

NO CONTACT
WITH GUSSET

D4434-043 FWD INBOARD
BRACKET

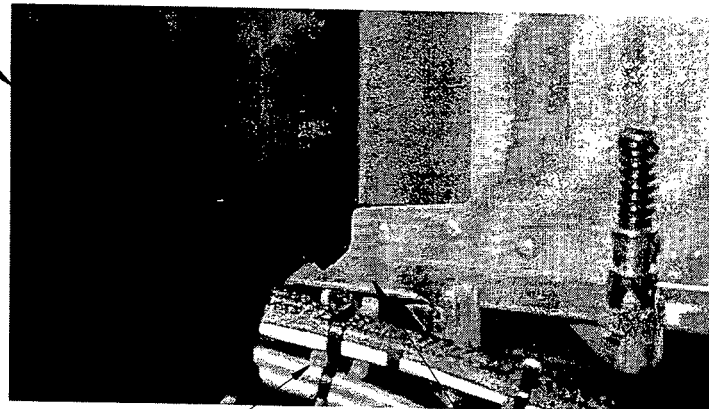
RBL 15.8



STA 70.5

Figure 5. D4436-045 & D4434-043 Brackets Installation

D4436-043
AFT OUTBOARD
BRACKET



CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

PLASTIC STAND OFF
REF

RIVET HOLE
FOR PLASTIC
STAND OFF

D4436-045
AFT INBOARD
BRACKET

Figure 6. D4436-043 & D4436-045 Brackets Installation

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92678

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

D4436-045
AFT INBOARD
BRACKET

RIVET HOLES
FOR PLASTIC
STAND OFF

--- RBL 15.8

PLASTIC STAND OFF
REF

D4434-043 FWD INBOARD
BRACKET

Figure 7. D4434-043 & D4436-045 Brackets Installation

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

RIVET HOLES
FOR PLASTIC
STAND OFF

--- RBL 15.8

D4434-043 FWD INBOARD
BRACKET

Figure 8. D4434-043 Fwd Inboard Bracket Installation

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MFG. APPR.	N/A	DSI 9590	SHEET 7 OF 12
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DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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92678

INSTALL
D4436-043
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

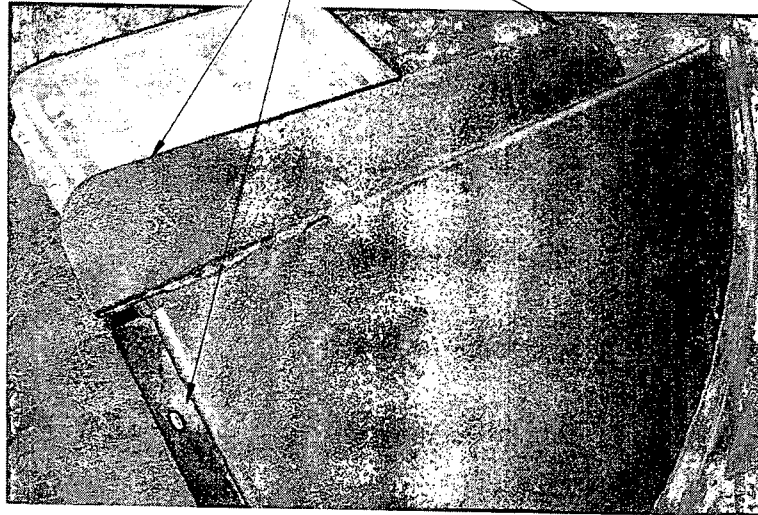


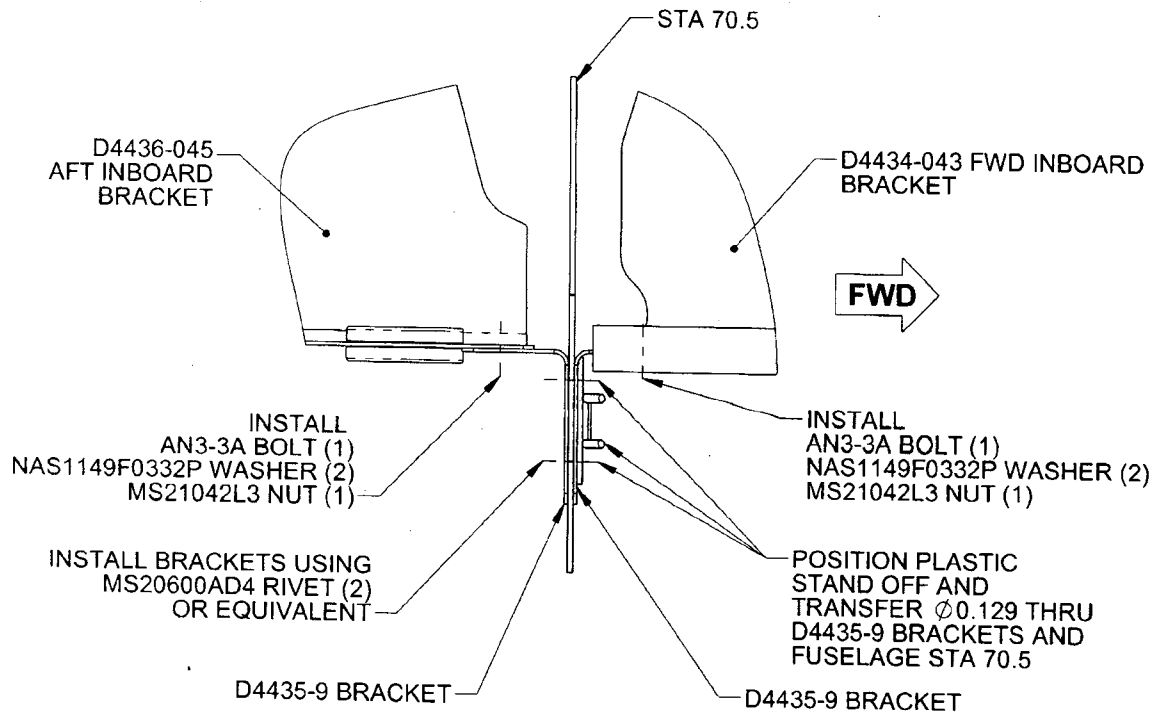
Figure 9. D4436-043 Aft Outboard Bracket Installation

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22628



LOOKING UP AT STA 70.5

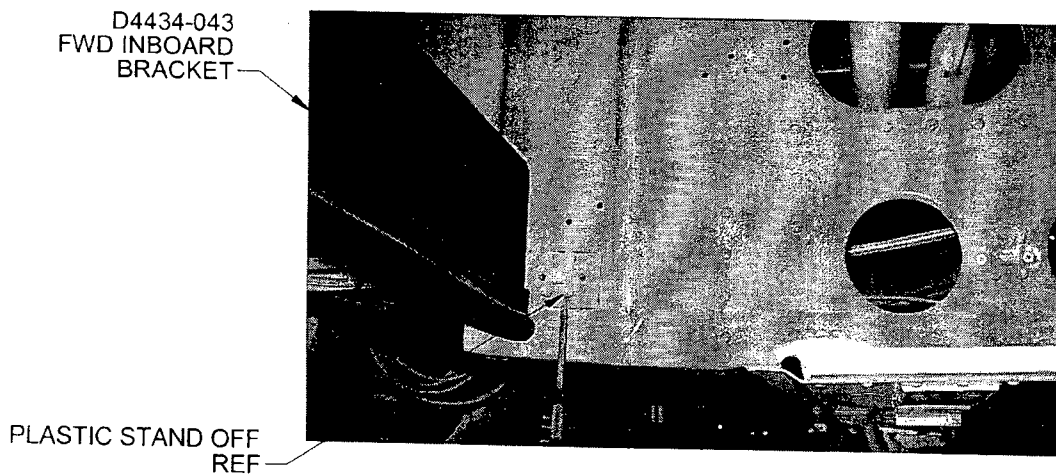


Figure 10. D4434-043 and D4435-9 Brackets Installation

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2x926

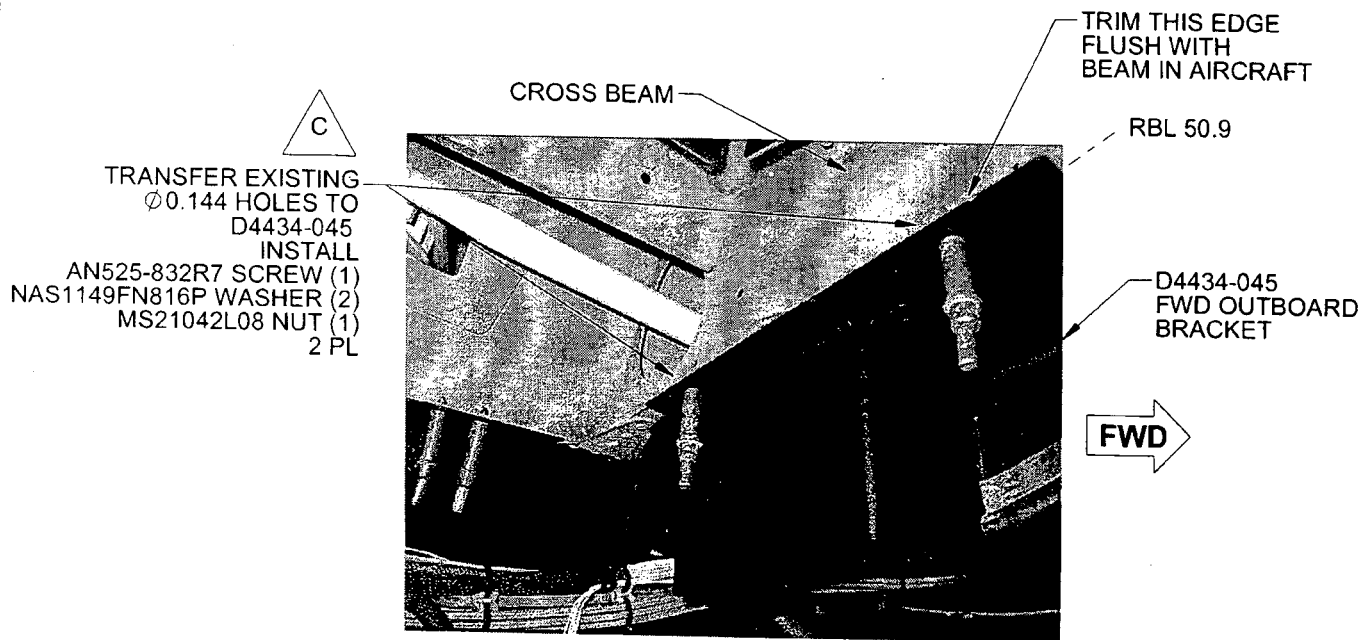


Figure 11. D4434-045 Bracket Installation

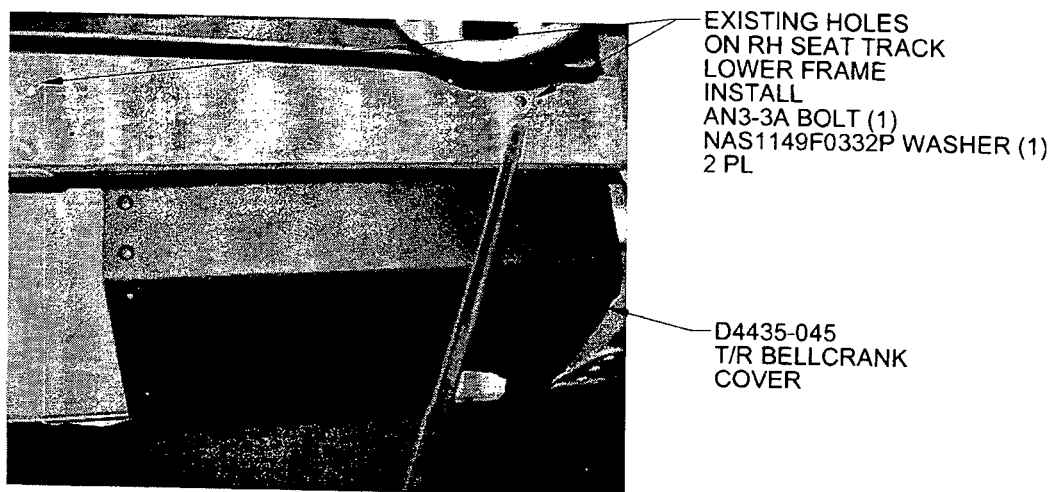


Figure 12. D4435-045 T/R Bellcrank Cover Installation

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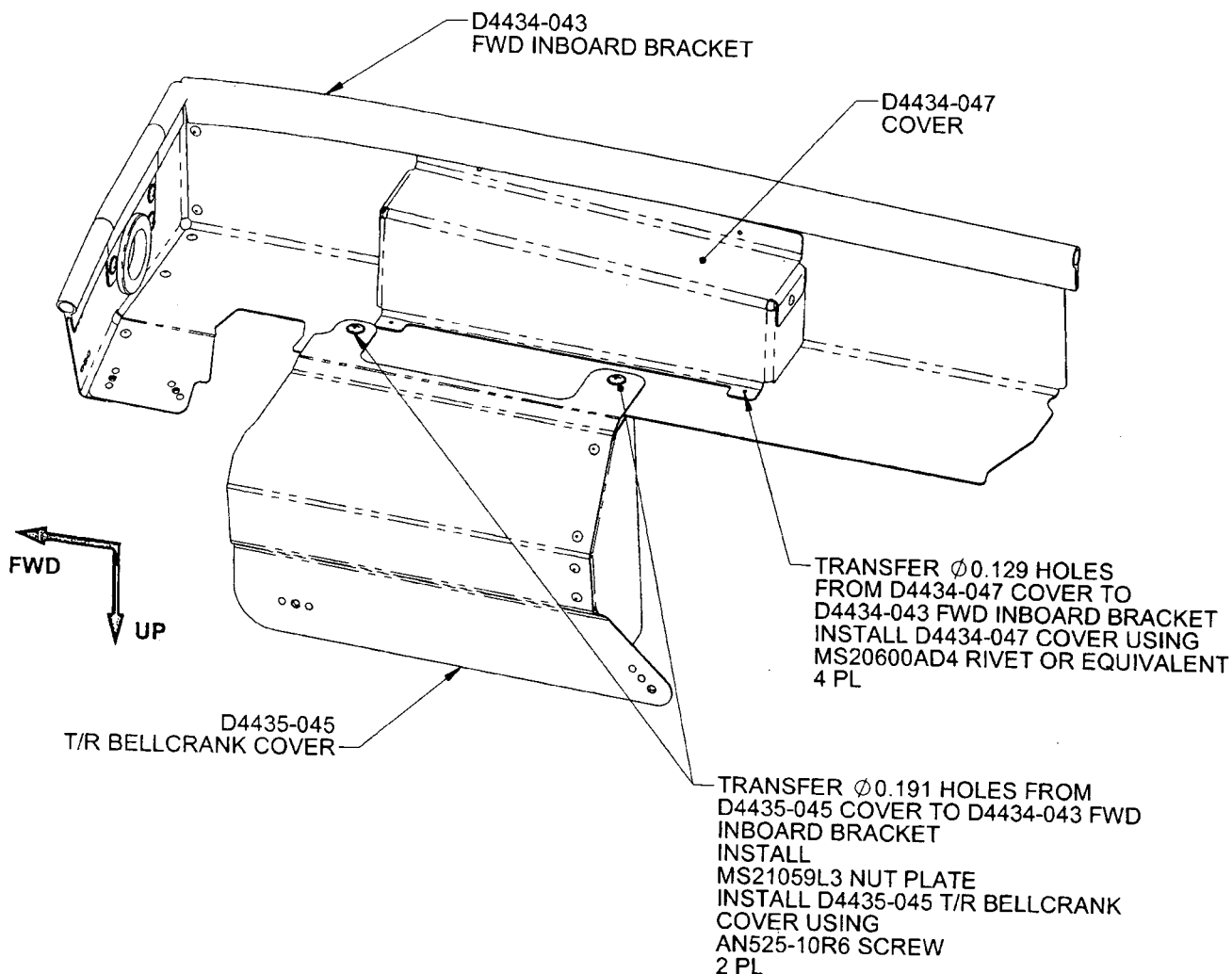


Figure 13. D4435-045 & D4434-047 Cover Installation

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82026

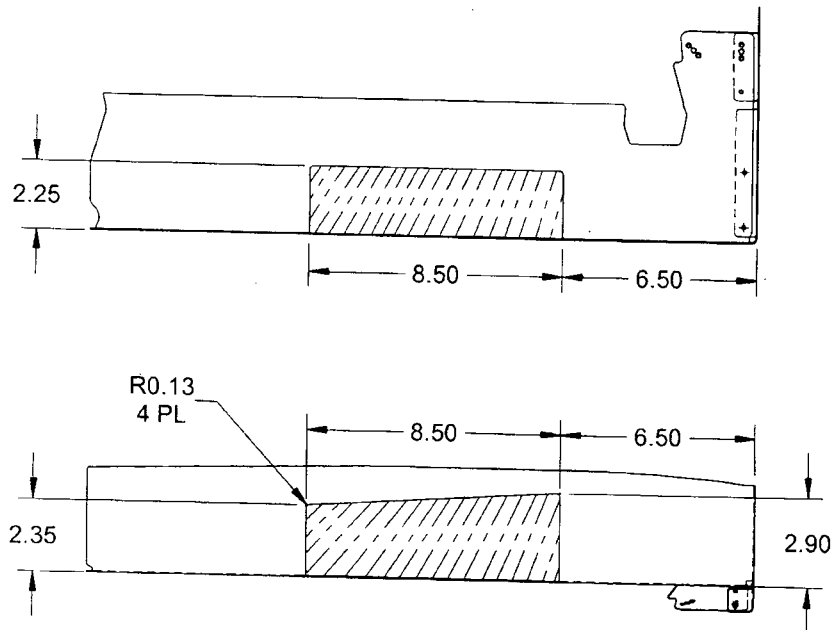
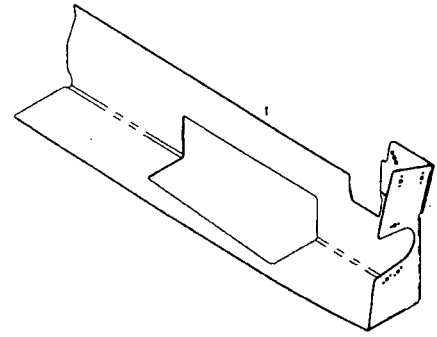


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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Refer to SMO

2.0 Part List

Qty	Part Number	Description
141		
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLECRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
6	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUT PLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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